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# Epoxy Tooling Board EB6200 (High Temperature)

BCC Products EB6200 is a blue “grain-free” elevated temperature epoxy modeling material known for its superior surface finish, dimensional stability and the ability to maintain tolerances even after being subjected to temperature variations. EB6200 Blue has excellent dimensional stability results from the low coefficient of thermal expansion and high glass transition temperature.

## Applications

Master Models (Aerospace); Automotive Die Models; Vacuum Forming at Elevated Temperatures; Lay-Up Tools for Medium and High Temperature Curing Prepreg.

## Board Dimensions

2 inches x 24 inches x 60 inches

4 inches x 24 inches x 60 inches

6 inches x 24 inches x 60 inches

## Typical Properties

PROPERTY	VALUE	TEST METHOD
Color	Blue	Visual
Hardness, Shore D	72	ASTM D-2240
Density, g/cm <sup>3</sup> (lbs/ft <sup>3</sup> )	0.64 (40)	ASTM D-792
Heat Deflection Temperature, °F	275	ASTM D-648
Glass Transition Temperature, °F	>305	ASTM D-3418
Coefficient of Thermal Expansion, in/in/°F	19.4 x 10 <sup>-6</sup>	TMA
Coefficient of Thermal Expansion, in/in/°C	35 x 10 <sup>-6</sup>	TMA
Izod Impact, Notched (Un-notched), ft-lbs/in	0.56 (1.05)	ASTM D-256

## Machining Information

Roughing	Finishing
<b>Speed:</b> 1,600 RPM	<b>Speed:</b> 10,000 RPM
<b>Feed:</b> 40 IPM	<b>Feed:</b> 100 IPM
<b>Cutters:</b> 1" Ball End Mill, 2-Flute, High Speed Steel (Minimum of 8% Cobalt Suggested)	<b>Cutters:</b> 5/8" Ball End Mill, 4-Flute, Carbide
<b>Depth:</b> 1/4" to 2" deep with a 40% step over	<b>Depth:</b> 1/8" deep leaving 0.002" scallop

A continuous air-blast is recommended during the cutting process to assist in cooling and evacuation of waste chips.

\*The machining information provided above is a suggested starting point. Individual users should determine the appropriate speeds, feeds, cutters and depths for their specific application.

NOTE: The information contained herein is believed to be reliable. All recommendations are made without guarantee inasmuch as conditions and methods of commercial use are beyond our control. Properties given are typical values and are not intended for use in preparing specifications. It is expressly understood and agreed that customer assumes, and hereby expressly releases BCC Products from, all liability, in tort, contract or otherwise, incurred in connection with the use of our products, technical assistance and information.